

Work Order ID 115519

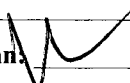
115519

Page 1

April-02-14 1:20:25 PM

Item ID: D412-742-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID:
 Item Name: Replacement Skidtube (Fits LH or RH) High Gear Apical & Oem Cylindrical Float Stop ***NS2***
 Start Date: 4/02/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 4/11/14 Req'd Qty: 1.00 ***1*** Customer:

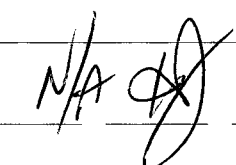
Reference:

Approvals: Process Plan  Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3391	I								

100 Document Control 0.00
100 DOCUMENT CONTROL

DC Memo 0.00
 Doc.Control -USB or Paperwork If D412-742-041 is a W/O on it's own,
 Photocopy bluefile and create labels per PPP D412-742-041 CHG005





Work Order ID 115519

April-02-14 1:20:25 PM

115519

Page 2

Item ID: D412-742-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Replacement Skidtube (Fits LH or RH) High Gear Apical & Oem Cylindrical Float Compatible

Start Date: 4/02/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 4/11/14 Req'd Qty: 1.00 ***1*** Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Per Hour	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Assemble as per dwg HandFinishing	0.00							
110	HandFinish	0.00							
Hand Finishing	Memo 1-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment. using 7/16" "T" Pins. A/RSikaflex-241/-291 <u>11130277</u> Expiry date: <u>12/02</u> 2-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Seal all bolts with sikaflex exept ones with inserts on inside of tube ,hand tighten only bolts with no sikaflex. A/RSikaflex-241/-291 <u>11130277</u> Expiry date: <u>12/02</u> 3-Remove "T" pins once sikaflex is dry. 4-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser. A/RLPS Procyon <u>11122900</u>								
120	QC5- Inspect part completeness to step on W/O	0.00							
120	QC	0.00							
Quality Control	Memo								

DAS
38
9-89

14-11-11

DAS
38
9-89

14-11-11

Work Order ID 115519

115519

Page 3

April-02-14 1:20:25 PM

Item ID: D412-742-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Replacement Skidtube (Fits LH or RH) High Gear Apical & Oem Cylindrical Float Compatible

Start Date: 4/02/14 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 4/11/14 Req'd Qty: 1.00 *1* Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130	Packaging	0.00							
Packaging	Memo	0.00							
	Identify and pack for shipping as per PPP D412-742-041								
	Location: 073								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140	QC	0.00							
Quality Control	Memo								

14/11/17

4-11-13

Picklist Print

April-02-14 1:20:23 PM

Page 1

Work Order ID: 115519

115519

Parent Item: D412-742-041

D412-742-041

Parent Item Name: Replacement Skidtube (Fits LH or RH) High Gear Apical & Oem Cylindrical
Float Compatible

Start Date: 4/02/14

Required Date: 4/11/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev A 05.10.13 New Issue KJ/JLM
IPP Rev 06.02.13 ECN 773 dwg @ rev.D EC
IPP Rev:C 07-05-28 As per Rev F JLM
IPP rev D 07.11.01 ecn 1053p EC
IPP rev E 07.11.27 ecn 1072 EC verified by:DD
IPP Rev:F 08-09-08 ecn 08-510 DD verified by:EC IPP Rev:G
10.02.24 as per ECN10-514 DD verified by: EC IPP Rev:H 11.11.01 as
per DSI9517 REV.B DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3391-013 *D3391-013* Mid Tube Assembly		Manufactured	No				Each	0.0000		1			
									**	B116813(1x) all w/1/1/14			
D3391-011 *D3391-011* Fwd Tube Assembly		Manufactured	No			110	Each	0.0000	1	1			
									**	B117008(1x) all w/1/1/14			
D3391-015 *D3391-015* Aft Tube Assembly		Manufactured	No			110	Each	0.0000	1	1			
									**	3120025(1x) all w/1/1/14			

Picklist Print

April-02-14 1:20:23 PM

Page 2

Work Order ID: 115519

115519

Parent Item: D412-742-041

D412-742-041

Parent Item Name: Replacement Skidtube (Fits LH or RH) High Gear Apical & Oem Cylindrical
Float Compatible

Start Date: 4/02/14

Required Date: 4/11/14

AN3C4A

Purchased

No

110

Each

Start Qty: 1.00
2,158.000 24 24

Required Qty: 1.00

AN3C4A

Bolt

**

all 14/4/14

Location

Loc Qty

Loc Code

FG

20

122814

20

11129520

✓24

ST350/513

1000

M128606

1000

ST512

3

124221

3

ST513

1135

125388

72

M127410

1

M127832

62

M128634

1000

AN3C6A

Purchased

No

110

Each

365.0000 10 10

AN3C6A

Bolt

**

all 14/4/14

Location

Loc Qty

Loc Code

FG

10

122416

10

11128769

✓10

ST351

12

m128224

12

ST513

343

m125709

343

Picklist Print

April-02-14 1:20:24 PM

Page 3

Work Order ID: 115519

115519

Parent Item: D412-742-041

D412-742-041

Parent Item Name: Replacement Skidtube (Fits LH or RH) High Gear Apical & Oem Cylindrical
Float Compatible

Start Date: 4/02/14

Required Date: 4/11/14

AN3C7A Purchased No

110 Each

Start Qty: 1.00
863.0000 4 4

Required Qty: 1.00

AN3C7A

Bolt

**

all wheels

Location

Loc Qty

Loc Code

FG 10

122141 10

ST513 853

m125709 853

NAS1149C0332R Purchased No

110 Each

9,570.000 38 38

NAS1149C0332R

WASHER

**

all wheels

Location

Loc Qty

Loc Code

GA 981

125654 981

ST292 4968

m128591 4968

st510 3621

m126319 61

m127306 2500

m127410 1034

m127831 26

MS27039C4-12 Purchased No

110 Each

174.0000 4 4

MS27039C4-12

SCREW

**

all wheels

Location

Loc Qty

Loc Code

ST308 174

124586 174

April-02-14 1:20:24 PM

Shop Packet Print

Page 3

Picklist Print

April-02-14 1:20:24 PM

Page 4

Work Order ID: 115519

115519

Parent Item: D412-742-041

D412-742-041

Parent Item Name: Replacement Skidtube (Fits LH or RH) High Gear Apical & Oem Cylindrical
Float Compatible

Start Date: 4/02/14

Required Date: 4/11/14

D3672-3

Manufactured No

110

Each

Start Qty: 1.00
1,635.000 4 4

Required Qty: 1.00

D3672-3

Phenolic Washer

**

all 11/11/14

Location

Loc Qty

Loc Code

FG

111

84432

11

89273

100

FP001

63

107316

63

ST060

1460

110251

8

112455

500

113746

952

ST061

1

93925

1

NAS1149C0432R

Purchased

No

110

Each

4,206.000 4 4

NAS1149C0432R

WASHER

**

all 11/11/14

Location

Loc Qty

Loc Code

GA

1719

m125807

1719

1130466

ST292

92

119124

6

121255

7

122441

79

ST510a

2395

m126221

2395

April-02-14 1:20:24 PM

Shop Packet Print

Page 4

Picklist Print

April-02-14 1:20:24 PM

Page 5

Work Order ID: 115519

115519

Parent Item: D412-742-041

D412-742-041

Parent Item Name: Replacement Skidtube (Fits LH or RH) High Gear Apical & Oem Cylindrical
Float Compatible

Start Date: 4/02/14

Required Date: 4/11/14

D4095-041

Manufactured No

110

Each

14.0000

Start Qty: 1.00

1

1

Required Qty: 1.00

D4095-041

Wearplate Assembly

all 14/11/14

Location

Loc Qty

Loc Code

FP002

14

B116989

109667

5

112409

9

D4095-043

Manufactured No

110

Each

9.0000

1

1

D4095-043

Wearplate Assembly

all 14/11/14

Location

Loc Qty

Loc Code

FP002

9

B117027

111932

9

D4095-045

Manufactured No

110

Each

12.0000

1

1

D4095-045

Wearplate Assembly

all 14/11/14

Location

Loc Qty

Loc Code

FP002

12

B116856

108288

1

109669

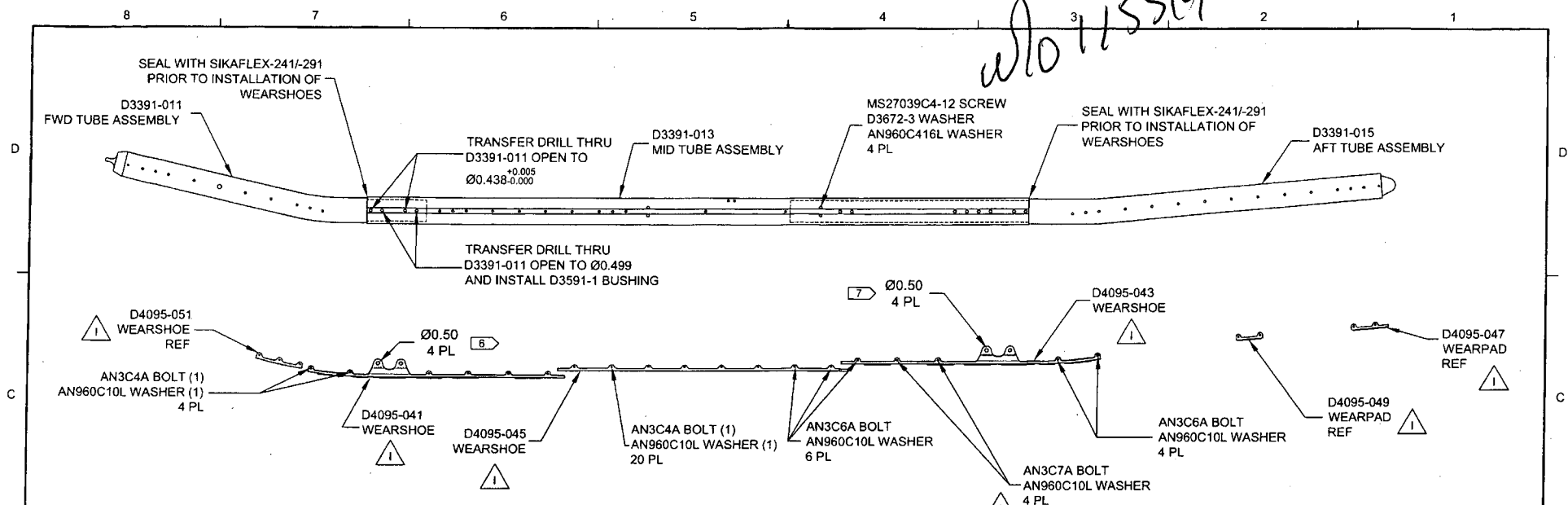
4

112308

7

all

W10115519



D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
-041		
X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
4	D3672-3	WASHER
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARPAD
1	D4095-049	WEARPAD
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.
- 6) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-041
- 7) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-043

RELEASED
2011-11-04
ECN#11-662

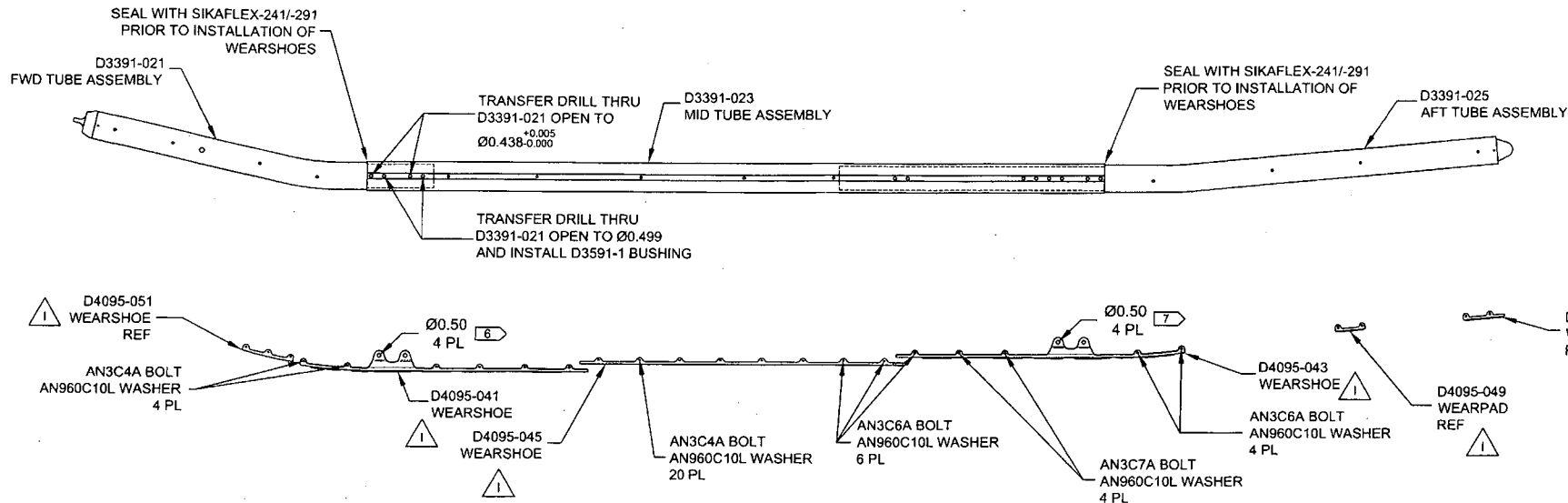
I	REMOVE GASKETS AND REPLACE ALL WEARSHOES; PARTS LIST UPDATE, ZN A8-1, ZN A8-2, ZN A6-4, ZN B6-8; LPS-3 COATING REMOVED FROM NOTE 2, ZN A3-1, ZN A3-2, REMOVED INSERT AELS-1032-130, ZN B6-4, B2-4, C7-8, C3-8; REMOVED HOLES, ZN D6-4 ZN D2-4, ZN D7-8, ZN D3-8	XDF	11.10.13
H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL. ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL. ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	XDF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.10.13		

DART AEROSPACE USA, INC
KENT, WA

DRAWING NO. REV. I
D3391 SHEET 1 OF 8

TITLE SCALE
412 FLOAT SKIDTUBE NTS

COPYRIGHT © 2005 BY DART AEROSPACE USA, INC
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.



D3391-043 ASSEMBLY

D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

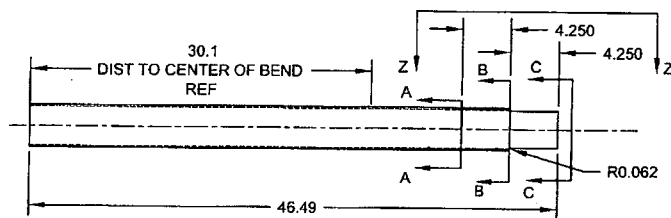
QTY	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARPAD
1	D4095-049	WEARPAD
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
36	AN960C10L	WASHER

GENERAL NOTES

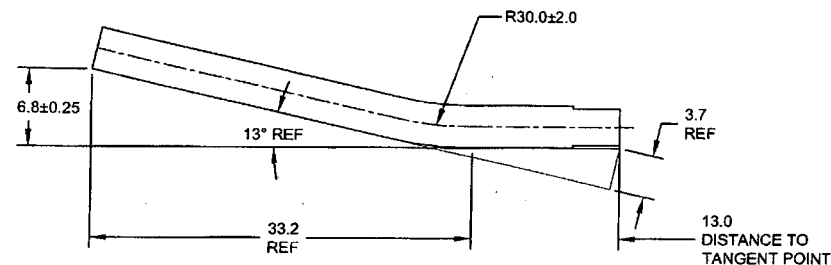
- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON"
AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES
FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT
WHERE INDICATED.
- 6) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH
APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND
TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-041
- 7) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH
THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND
TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-043

RELEASED
2011-11-04

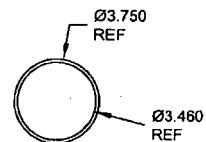
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED		DRAWING NO.	REV. 1
MFG. APPR.		D3391	SHEET 2 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	11.10.13	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



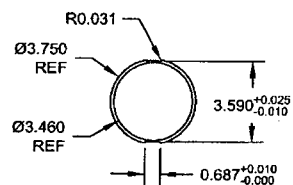
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



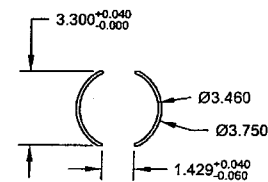
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



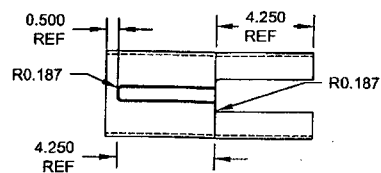
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



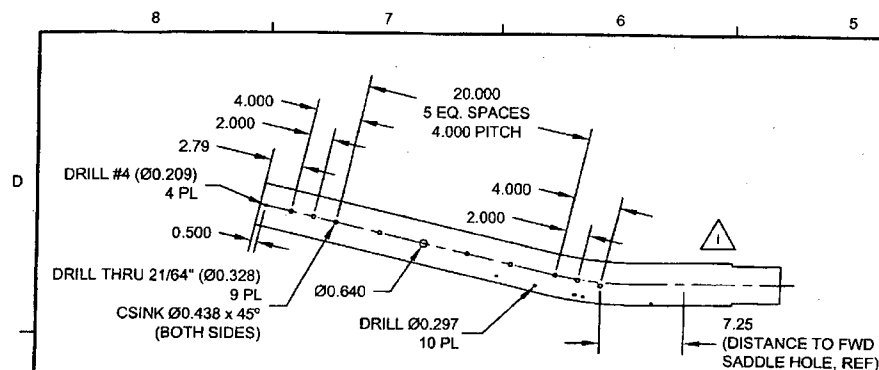
SECTION C-C
SCALE 2X



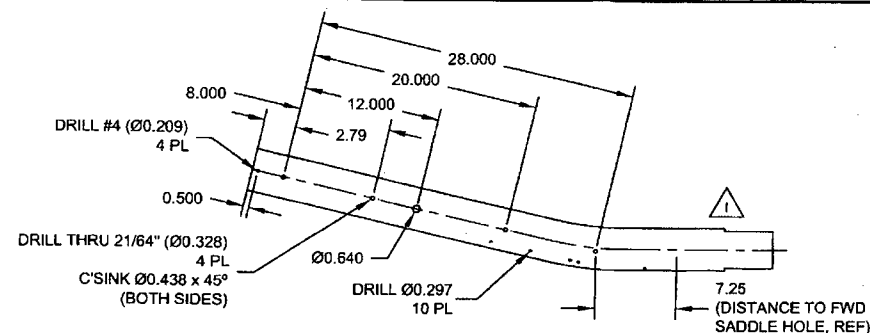
VIEW Z-Z
SCALE 2X

RELEASED
2011-11-04

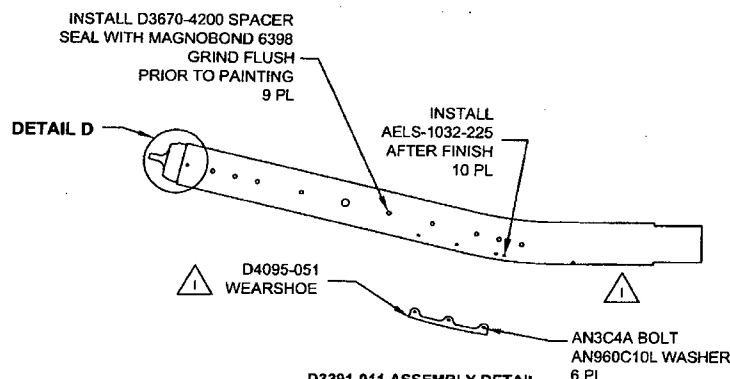
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED		DRAWING NO. D3391	REV. 1
MFG. APPR.		SHEET 3 OF 8	
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	11.10.13	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



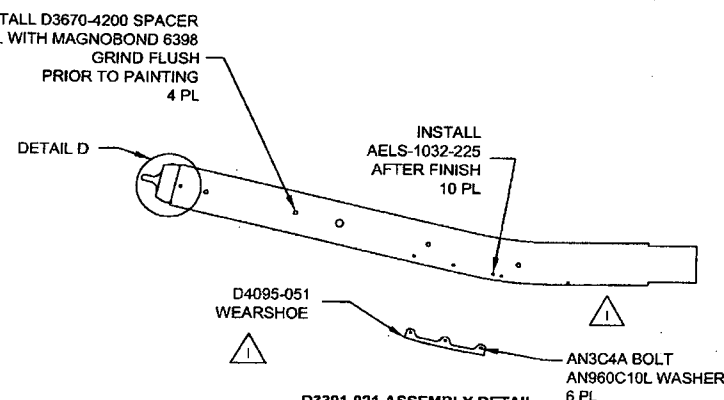
D3391-011 DRILLING DETAIL



D3391-021 DRILLING DETAIL



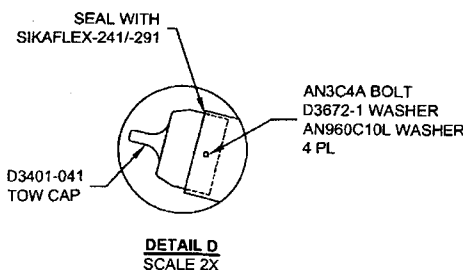
D3391-011 ASSEMBLY DETAIL



D3391-021 ASSEMBLY DETAIL

D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST

QTY - 011	QTY - 021	PART NUMBER	DESCRIPTION
X		D3391-011	FWD TUBE ASSEMBLY
	X	D3391-021	FWD TUBE ASSEMBLY
1	1	D3401-041	TOW CAP
9	4	D3670-4200	SPACER
4	4	D3672-1	WASHER
1	1	D4095-051	WEARSHOE
1	1	D6013-047	FWD TUBE
10	10	AN3C4A	BOLT
10	10	AN960C10L	WASHER
10	10	AELS-1032-225	INSERT

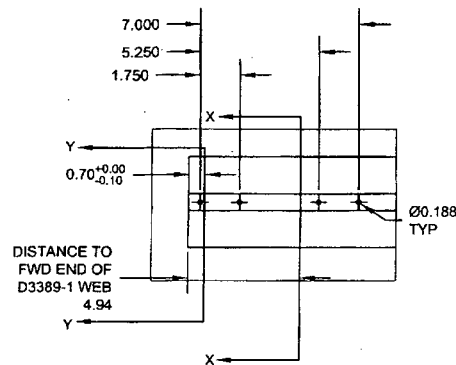


**DETAIL D
SCALE 2X**

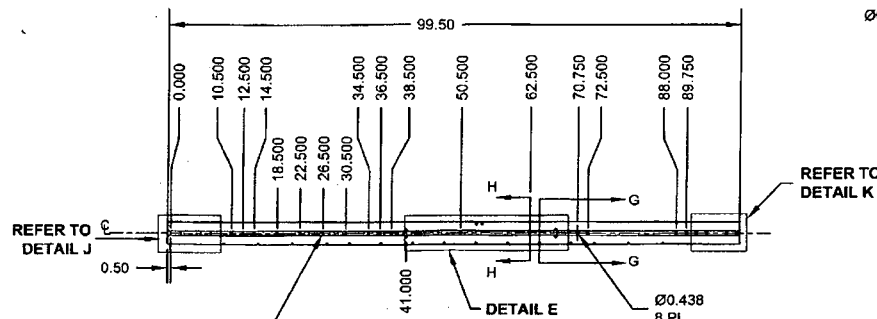
RELEASED
2011-11-04

DESIGN		PH		DART AEROSPACE USA, INC	
DRAWN		XDF		KENT, WA	
CHECKED				DRAWING NO. REV. 1	
MFG. APPR.				D3391 SHEET 4 OF 8	
APPROVED				TITLE SCALE	
DE APPR.				412 FLOAT SKIDTUBE NTS	
DATE		11.10.13		COPYRIGHT © 2005 BY DART AEROSPACE USA, INC	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.					

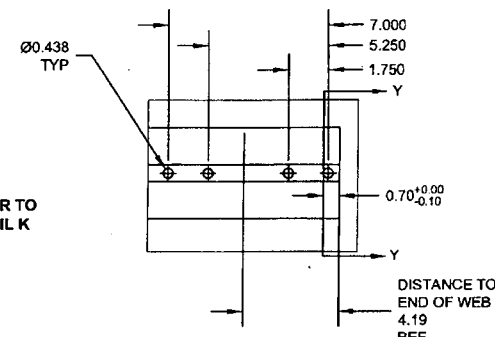
8 7 6 5 4 3 2 1



DETAIL J
SCALE 4X



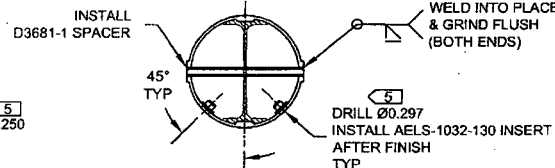
D3391-013 ASSEMBLY DETAIL



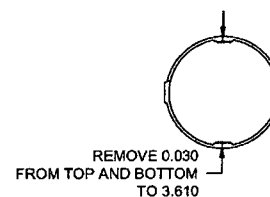
DETAIL K
SCALE 4X



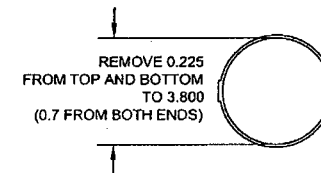
SECTION G-G
SCALE 5X



SECTION H-H
SCALE 5X



SECTION X-X
SCALE 5X



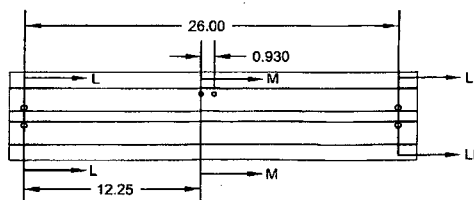
SECTION Y-Y
SCALE 5X

D3391-013 MID TUBE ASSEMBLY PARTS LIST

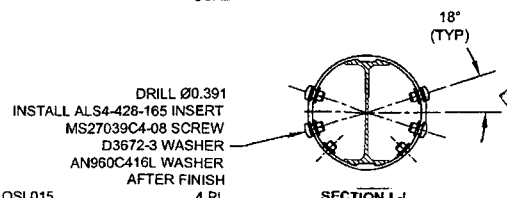
QTY -013	PART NUMBER	DESCRIPTION
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW

D3391-013 MID TUBE ASSEMBLY

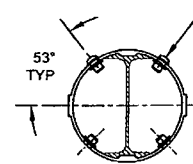
- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004



DETAIL E
SCALE NONE



SECTION L-L
SCALE 5X



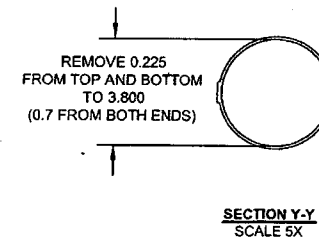
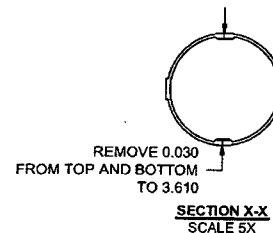
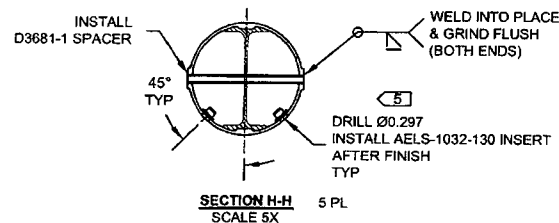
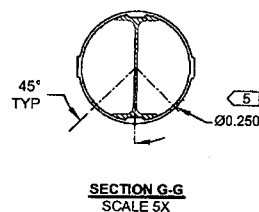
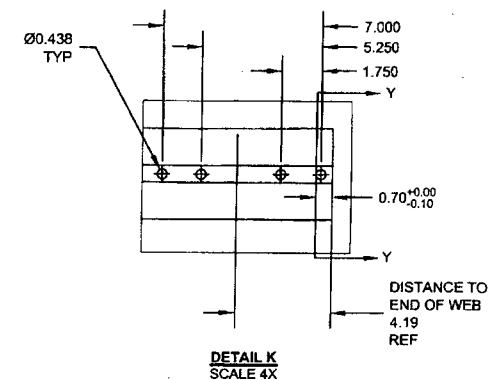
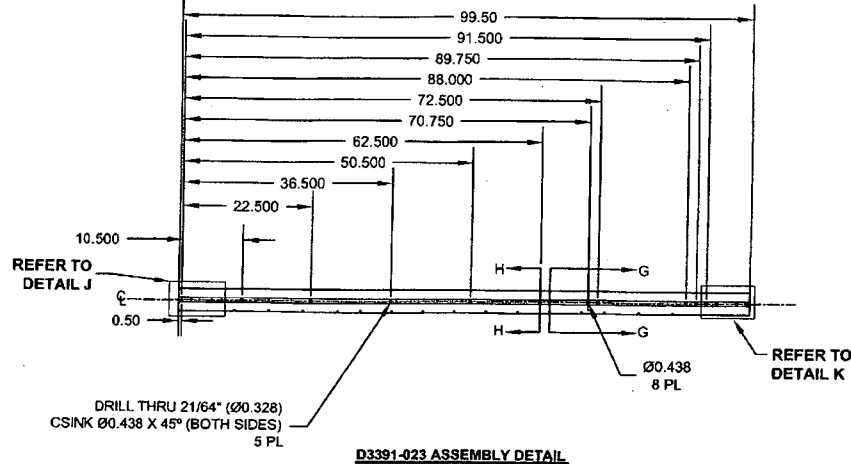
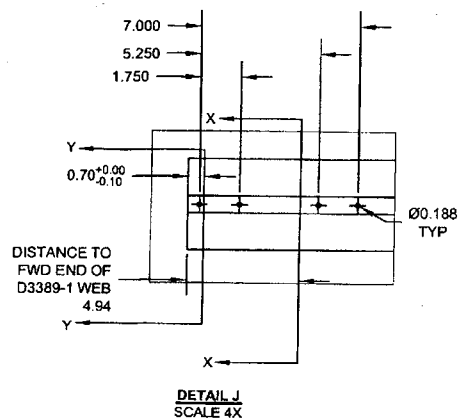
SECTION M-M
SCALE 5X



SECTION LL-LL
SCALE 5X

RELEASED
2011-11-04

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED		DRAWING NO.	REV. I
MFG. APPR.		D3391	SHEET 5 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	11.10.13	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



D3391-023 MID TUBE ASSEMBLY PARTS LIST

QTY - 023	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

D3391-023 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015
- 3) WELDING: PER DART QSI 004

RELEASED
2011-11-04

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED		DRAWING NO.	REV. 1
MFG. APPR.		D3391	SHEET 6 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	11.10.13	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR CONTENT OR COMMUNICATED TO ANY OTHER PERSONS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

